

Date: Wednesday, 12/7/2005 8:29:06 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CONSOLE BRACKET HI-SLOPE	
Job Number	: 25142		Part Number	: D2606	
Estimate Number	: 11004		Drawing Number	: D2606 REV A1	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 12/7/2005	S.O. No. : N/A	Drawing Revision	: A1	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: 12/7/2005	Type : MACHINED PARTS	Due Date	: 1/10/2006 Qty: <i>19</i>	
Previous Run	: N/A		Um:	Each	
Written By	: SEE COMMENT BELOW				
Checked & Approved By	: SEE COMMENT BELOW				
Comment	: Est. D 98.11.26 Added Inspection DM				

## Additional Product

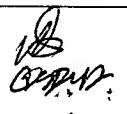
Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet 
		Comment: Qty.: 0.1582 sf(s)/Unit Total : 3.1647 sf(s) 2024-T3 .040 sheet Material: 2024-T3 (QQ-A-250/4) 0.040" thick Stack of 10 (M2024T3S.040) Batch <i>M19057</i> <i>Ep 05/21/16 20</i>
2.0	SHEAR	SHEAR 
		Comment: SHEAR <i>9.000" x 2.500" (+ - 0.030)</i> Cut Blank per template DT8247 <i>Ep 05/21/16 20</i>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine per folio D2606 <i>Ep 05/21/16 20</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>Ep 05/21/16 20</i>
5.0	QC8	SECOND CHECK 
		Comment: SECOND CHECK <i>J.L. 05-10-16 20</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 05/12/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05/12/16	# 3.0	one stack scrap (10 parts) was in Clamps.		Scrap and Destroy and Replace.	E.P. 05/12/16	 05-12-16	 05-12-16	 05-12-16

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr

Form as per Dwg D2606

SB 06/01/14 20

SAD 1/18/12/05 20

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FF 06.01.19 RE-  
SAD 17/12/05 20

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 48



DOCUMENT CONTROL

ml 06/01/27

19

(19)

Comment: DOCUMENT CONTROL

Inspection Level 21

595 06/01/30

SD 06/01/30

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

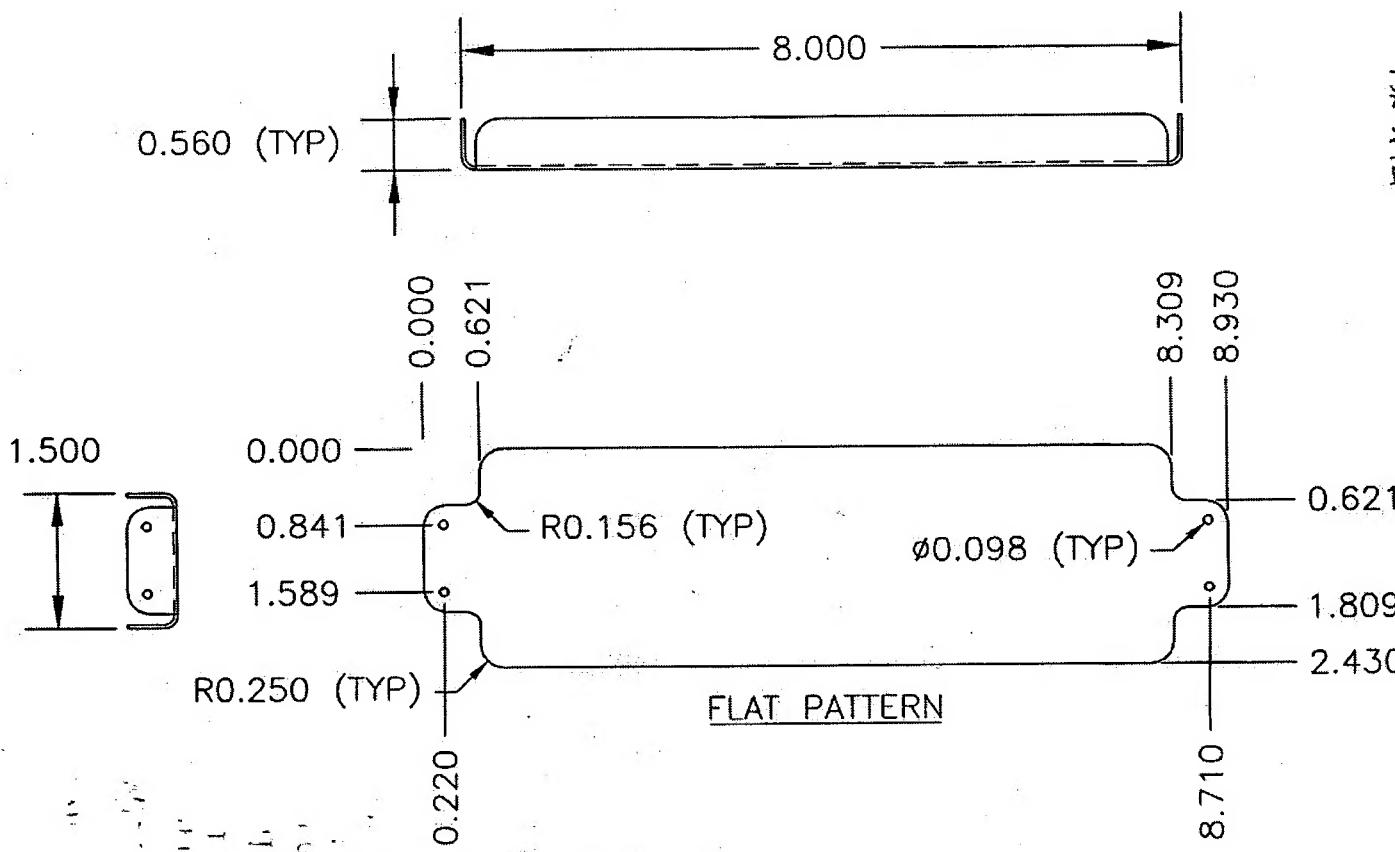
DART AEROSPACE LTD	Work Order:	25142
Description: Console Bracket	Part Number:	D2606
Inspection Dwg: D2606	Rev: A1	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>Eg</u>	Audited by:	<u>J.L</u>	Prototype Approval:	N/A
Date:	05/12/16	Date:	05.12.16	Date:	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	05.02.17	New Issue	KJ/JLM	



MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK  
 PROFILE CONTROLLED BY FOLIO H2606  
 BEND RADIUS 0.093

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 /AI

**RELEASED**  
 97.11.04 KE  
 TSR A424

**DART**



DESIGNER	DRAWN BY	DART AEROSPACE LTD	
	BW	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	REV. A	
	JF	DRAWING NO.	SHEET 1 OF 1
DATE		D2606	SCALE
97.10.23		CONSOLE BRACKET	1:2
A	97.10.23	D2606 WAS D206-547-27	
A1	02.06.04	ADD FINISH	

25142